MIG HBF17

Old reference: MIG HBCrMo17-1

Classification

DIN 8555 : MSG 6-GZ-50-RZ
EN 14700 : S Fe8

Material N° : 1.4122

Description & Applications

Solid wire for GMAW for surfacing. Used for hardfacing parts subject to corrosion and heat as well as for cold working tools. For gas, water and steam valves with service temperatures up to 500°C.

Main applications: Hardfacing and welding of base metals X55CrNiMoV12, X55Cr14, X160CrMoV12

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Fe
0.4	0.5	0.4	16.5	1.1	Rem.

All Weld Metal Mechanical Properties

Hardness
~53 HRC

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
GMAW = +	0.8 1.0 1.2 1.6	100-150 150-190 150-220 180-270	22-27 25-28 25-28 26-32	EN 439: M1 (Ar+2%CO_2) 12-15 l/min

Tool steels have to be preheated to 350-450°C, depending on the thickness and composition.

Ind.10

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